

Date: Thursday, 3/30/2006 8:30:10 AM
User: Kim Johnston

Process Sheet

16

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B
Job Number : 26404
Estimate Number : 10163
P.O. Number : N/A Part Number : D206642241
This Issue : 3/30/2006 S.O. No. : N/A Drawing Number : D2650 REV D1
Prsht Rev. : NC Project Number : N/A
First Issue : N/A Type : LANDING GEAR Drawing Revision : D1
Previous Run : 26403 Material : N/A
Written By : Sally Comment Below Due Date : 4/20/2006 Qty: 1 Um: Each
Checked & Approved By : 06.03.30
Comment : Est Rev:M 04.12.02 Revised procedural steps KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D206-642-241 CHG003

DH 06/05/04

2.0 D2620 Bent 206 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2620 Bent Tube 3" OD B26750

Pmc 06-04-170

3.0 D32861 Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3286-1 Doubler B24206

Pmc 06-04-250

4.0 D2647 Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2647 Fwd Cap B220535

BE 06-04-180

5.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr Fwd edge of tube

Pmc 06-04-170

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:

WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B

Job Number: 26404

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description:

2- Remove ridge on inside of Fwd edge of tube as per Dwg D2650 *pm 06-04-17 ①*

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required. *BE 06-04-18 ①*

Pick:

Qty Part Number Description Batch

A/R Aluminum Rod *m19101/m18839 BB 06-04-18 ①*

4-Grind weld flush to cap on top surface only.

5-Cut Aft end as per dwg 2650 from front of tube and Deburr

6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D2650

7-Open holes for Aft end cap as per Dwg D2650 with #30 Drill Bit using DT8025.

8-Drill pilot holes using Dt 8167.

9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support.

10- Drill D3286-1 doubler rivet holes in tube using # 40 drill, spot drilling doubler at the same time.

11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads.

12-Remove and Deburr D3286-1 doubler

13-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D2650

14-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder

15-Remove indexing edge using DT8741 as per Dwg D2650

16-C'sink GHW rivet holes as per Dwg D2650

6.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

06-04-26 ①



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 26404

Part Number: D206642241

Job Number:



Seq. #: Machine Or Operation: Description :

7.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open crossbolt holes to Ø0.3125" as per Dwg D2650

Pm' 06-04-27

2-Drill pilot holes using DT8028-3, then open to Ø0.297" as per Dwg D2650. Open Aft cap hole #6.

Pm' 06-04-27

3-Deburr tube and blow out chips from inside the tube

Pm' 06-04-27

8.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Pm' 06-04-27

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BE 06-04-27 (1)

10.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open holes to finished size as per Dwg D2650, D2650-3 Drilling Detail (without cutting fluid)

2-C'sink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

Pm' 06-04-27

3-Deburr and blow out all chips from inside the tube

11.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

BE 06-04-27 (1)

12.0 CR3212404 Cherry Rivet



Comment: Qty.: 52.0000 Each(s)/Unit Total: 52.0000 Each(s)

Pick:

Qty Part Number Description Batch

52 CR3212-4-04 Rivet *m100203*

Pm' 06-04-28 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 26404

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Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

D26543

206 I-Beam (Web)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2654-3

Web

B26865

Pm' 06-04-28 ①

14.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Locate, install and rivet doublers as per Dwg D2650. Micro-shave rivets as required

Pm' 06-04-28 ①

2-Bond D2654-3 web in place as per QSI 015. Ensure holes line up. Allow 12 Hrs. cure time before cutting

Start Date: 06-04-28

Time: 9:45

Finish Date: 06-05-01

Time: 10:00

Pick:

Qty Part Number

Description Batch

A/R Sikaflex-291

M100480

Sikaflex expire date:

06-11-01

Pm' 06-04-28 ①

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DP 06-5-1

①

16.0

D2649

Crossbolt Spacer



Comment: Qty.: 18.0000 Each(s)/Unit Total: 18.0000 Each(s)

Pick:

Qty Part Number

Description Batch

18 D2649

Crossbolt spacer

B24200 BE 06-05-1- ①

17.0

D32863

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D3286-3

Spacer

B24711 BE 06-05-02 ①

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 26404

Part Number: D206642241

Job Number:



Seq. #:	Machine Or Operation:	Description :
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18.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

Pick:

Qty Part Number Description Batch

A/R Aluminum Rod

m18839 BE 06-05-01 (1)

2-Grind welds flush as per Dwg D2650.

BE 06-05-02 (1)

3-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D2650. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required.

A/RSS Rod

NONE

BE 06-05-02 (1)

4-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D2650. Deburr

BE 06-05-02 (1)

19.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CCR264SS3-3 Rivets

m18518 Pm 06-05-03 (2)

20.0

M7885343

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 M7885/3-4-3 Rivets

m19099

Pm 06-05-03 (2)

21.0

D2680041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2680-041

Nut Plate

B24263

Pm 06-05-03 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Part Number: D206642241

Job Number:



Seq. #: Machine Or Operation: Description :

22.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install D2680-041 Nut Plate as per Dwg D2650

pm 06-05-03 (1)

23.0 QC5/9 WELD INSPECTION



Comment: Inspect weld and Counterbore work to Current Step. Inspect for foreign objects as per QSI 024

24.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref. 4.3.5.1) as per QSI 005 4.3. Make sure Nut Plate Thread is protected using paint screw, and mask GHW studs.

Dr 06/06/02

25.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

am 06-06-05 (1)

26.0 D26483 Wearpad



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch
06.03.36 *14* D2648-3 Wearpad *B 25904*

27.0 D265613 Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D2656-13 Wearshoe *B 25914*

28.0 D265621 Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D2656-21 Wearshoe *B 220532*

am 06-06-05 (1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

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Job Number: 26404

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

D265633

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2656-33

Wearshoe

B20013

30.0

D34291



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3429-1

Wearpad

B24417

31.0

ALS41032130

Insert



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

44 ALS4-1032-130 Inserts

M18293

or (see QSI 017)

32.0

AN960JD10L

Washer



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

44 AN960JD10L

Washer

M18236

33.0

MS27039108

Screw



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

44 MS27039-1-08

Screw

M18836

C.m 06-06-05 (1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 26404

Part Number: D206642241

Job Number:



Seq. #:	Machine Or Operation:	Description :
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34.0	D26511	Plug
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Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
18	D2651-1	Plugs	B25365

35.0	D26513	O-Ring
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Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
18	D2651-3	O-Rings	B23491

36.0	MS27039406	Screw
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	MS27039-4-06	Screw	M6874

37.0	AN960JD416	Washer
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN960JD416	Washer	M11151

38.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1]

1- Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/R Sikaflex-291 M12126
Sikaflex expire date: 06-11-06

2-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive.

3-Install MS27039-4-06 Screw as per DEO 9153.

a.m 16-06-05 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

39.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect for foreign objects as per QSI 024

DL 06-06-05

40.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2646

Aft Cap

B 233703

41.0

MS27039108

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 MS27039-1-08 Screw

M 14136

42.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 AN960JD10L Washer

M 14135

a.m. 06-06-05

43.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive

A/R Sikaflex-291

Sikaflex expire date:

M 10126
06-06-05

a.m. 06-06-05

2-Wing Walk as per Dwg D2650-3 and QSI 005 4.4

Batch: *M 100652*

a.m. 06-06-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: *LD* Date: 06/06/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Seq. #:

Machine Or Operation:

Description :

44.0

QC3/5

INSPECT WORK/WING WALK



Comment: INSPECT WORK/WING WALK

DL

06/06/09

(1)

45.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/06/12
u 0606-12

(1)

Job Completion



446 PK

package per PPD

PPD D206-642-241

NEUF

6/6/91

W/O:		WORK ORDER CHANGES					
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DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>HH</i>	APPROVED <i>HH</i>	DRAWING NO. D2650	REV. D SHEET 1 OF 5
DATE 04.05.17		TITLE 206/407 SKIDTUBE ASSEMBLIES	SCALE NTS
A	97.03.25	NEW ISSUE	
B	97.06.26	AS MANUFACTURED CHANGES	
C	97.10.29	CHANGE HOLE PATTERN AND FRONT END	
D	04.05.17	REDRAW; INCORP. DE09136/9153/9163 MOD GROUND HNDLNG ON D2650-1/-3	

RELEASED
04.06.22 *HH*

Qty -1	Qty -3	Qty -5	Qty -7	Part Number	Description
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
16	17	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

NOTES

- 1) WELD PER DART QSI 004
- 2) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 3) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 4) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 5) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 6) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 7) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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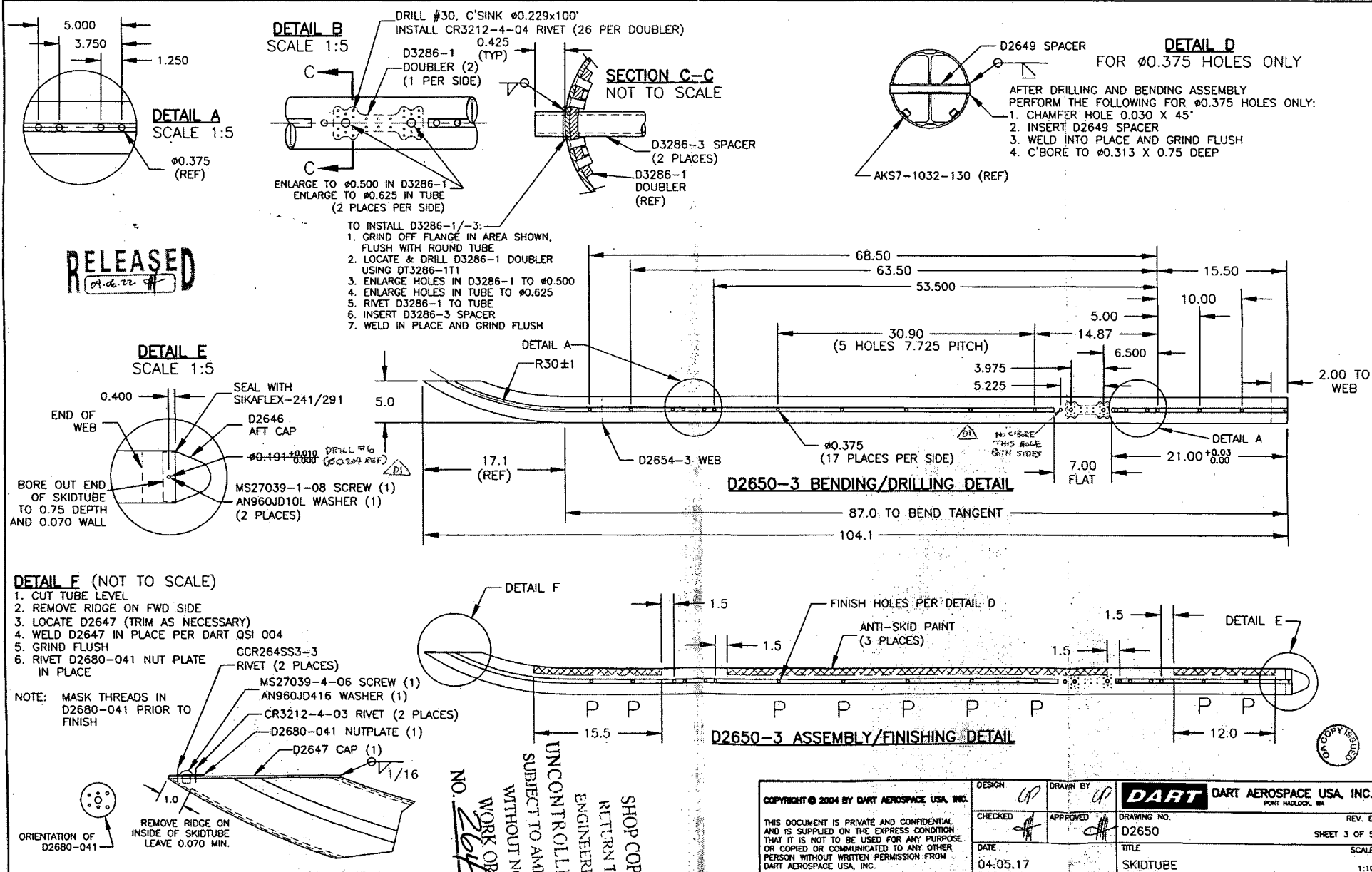
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WITHOUT NOTICE

WORK ORDER
NO. 26404

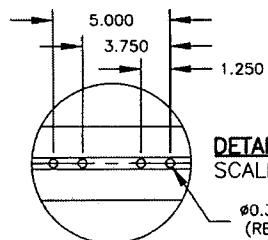
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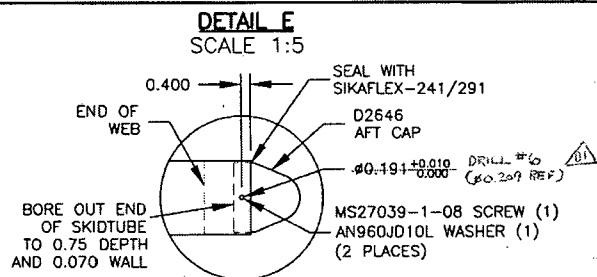
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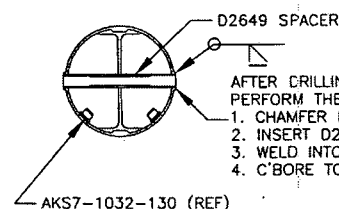
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DETAIL A
SCALE 1:5



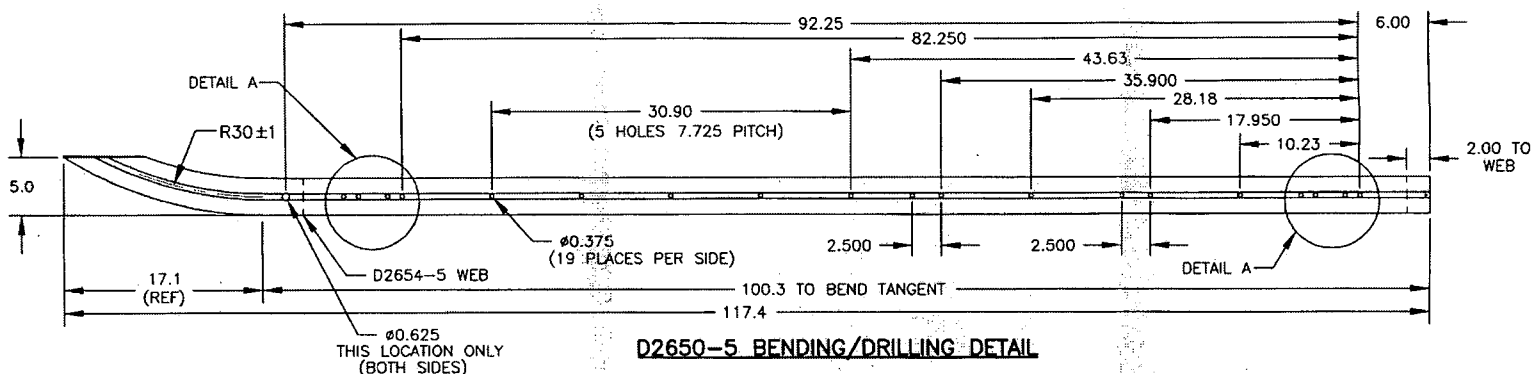
DETAIL E
SCALE 1:5



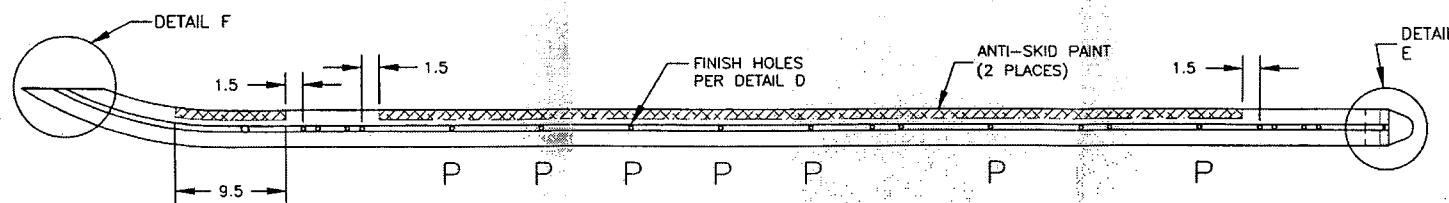
DETAIL D
FOR Ø0.375 HOLES ONLY

- AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.030 X 45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE TO Ø0.313 X 0.75 DEEP

RELEASED



D2650-5 BENDING/DRILLING DETAIL

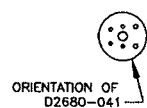


D2650-5 ASSEMBLY/FINISHING DETAIL

DETAIL F (NOT TO SCALE)

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH



REMOVE RIDGE ON INSIDE OF SKIDTUBE LEAVE 0.070 MIN.

- CCR264SS3-3 RIVET (2 PLACES)
- MS27039-4-06 SCREW (1)
- AN960JD416 WASHER (1)
- CR3212-4-03 RIVET (2 PLACES)
- D2680-041 NUTPLATE (1)
- D2647 CAP (1)

NO. 26404
WORK ORDER
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DESIGN

DRAWN BY

CHECKED

APPROVED

DATE

04.05.17

DART DART AEROSPACE USA, INC.
PORT HANCOCK, WA

DRAWING NO.

D2650

TITLE

SKIDTUBE

REV. D

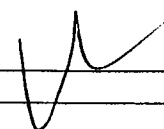
SHEET 4 OF 5

SCALE

1:10

Date: Thursday, 11/10/2007 2:26:44 PM
 User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : D206-642
Job Number : 35132	
Estimate Number : 10804	
P.O. Number :	Part Number : Z_CUSTOM
This Issue : 11/10/2007 S.O. No. :	Drawing Number : ECN 1046-PAPERWORK
Prsht Rev. : NC	Project Number :
First Issue : / / Type : LANDING GEAR	Drawing Revision :
Previous Run : 00015	Material :
Written By : 	Due Date : 18/10/2007 Qty: 1 Um: Each
Checked & Approved By : _____	
Comment : _____	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
 REMOVE FROM STOCK:

D206-642-111 15614 15615
 D206-642-112 10319 25504
 D206-642-141 9575 18613
 D206-642-211 33078 32559 - 32565 - 33795 - 33776
 D206-642-212 32257 32567 - 32566 - 32568 - 33079 - 33080 - 33242
 D206-642-213 19735
 D206-642-214 24414 - 24484 - 28083 - 29084 - 32983 - 32984
 D206-642-241 26097 - 26404 - 33211 - 33342
 D206-642-311 28847
 D206-642-312 29741 - 15619 - 29742 - 29741
 D206-642-341 27451 - 27452 x x x
 D206-642-411 34557 - 34056 - 34555 - 34556 - 32495 - 31980
 D206-642-411BL 34132 x x x x x
 D206-642-412 34564 - 34563 - 34562 - 34060 - 34059 - 32502 - 34058
 D206-642-412BL 34135
 D206-642-441 31066 - 30940 - 30260 - 30265 - 24239
 D206-642-511 34592 - 34579 - 33848 - 34581
 D206-642-512 34586 - 34584 - 34583 - x
 D206-642-513 _____
 D206-642-514 _____
 D206-642-541 _____
 D206-642-611 _____
 D206-642-612 _____

ADD NEW PAPERWORK EASA.IM.R.S.01320 REV.1
 PER ECN 1046

1-11-07 SP